

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008853**Date Inspected:** 08-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

CB4

FCAW welding of weld joints 013~024 located on SP201-001.

Welder is identified as Mr. Cao Cai Jun (220064). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234 and WPS-B-T-2132.

FCAW welding of weld joints 021~024 located on FB203-001.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234 and WPS-B-T-2132.

5BE & 5CE

FCAW welding of weld joints 005~021 located on SP305A-001.

Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

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FCAW welding of weld joints 020~030 located on SP332A-001.

Welder is identified as Mr. Li Shuqing (220066). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

5BW

FCAW welding of weld joints 005~012 located on FB025-001.

Welder is identified as Mr. Cao Cai Jun (220064). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234 and WPS-B-T-2132.

5BE

FCAW welding of weld joints 173 and 174 located on SSD17-001.

Welder is identified as Mr. Cao Cai Jun (220064). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234 and WPS-B-T-2132.

1BE

SMAW welding (repair) on side plate stiffeners on panel point 12.5 bike path side of segment.

Welder is identified as Mr. Ha Yanming (062092). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

1BE & 1AE

SMAW welding of weld joint 013 located on EP104-001.

Welder is identified as Mr. Zhang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair, WPS-345-SMAW-1G (1F)-Repair and repair procedure B-WR-7356.

3BW

This QA Inspector perform MT of area previously tested and accepted by Quality Control on OBG 3BW. QA Inspector observed one transverse indication, measuring approximately 2mm in length respectively. Noted transverse indication is located on bottom plate stiffener (3rd from the bike path side of segment) at Panel Point 18.

This area was previously MT tested and accepted by Quality Control Department. This QA Inspector issued an incident report on the above noted MT rejection.

Office

This QA Inspector and QA Inspector Dan Hernandez were called into the office to provide information of yesterday incident to ABF and Caltrans upper management personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
